

Date: Monday, 5/26/2008 1:09:46 PM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 AFT CANOPY		
Job Number	: 39494			Part Number	: D36561		
Estimate Number	: 13098			Drawing Number	: D3656 REV A		
P.O. Number	:			Project Number	: 00204		
This Issue	: 5/26/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 5/27/2008		
Previous Run	: 38505			Qty:	1	Um:	Each
Written By	:			Comment	: Est. Rev. A 07/12/13 DL verified by:DD		
Checked & Approved By	: <u>JO 08.5.26</u>						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
	Comment: Qty.: 32.0000 sf(s)/Unit Total : 32.0000 sf(s) GE PLASTICS LEXAN SHEET batch: M 105494	<i>JO</i>
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING	<i>JO 08.05.27</i>
	1) Cut Blanks to fit frame size	
3.0	THERMOFORMING	THERMOFORMING MACHINE
	Comment: THERMOFORMING MACHINE	<i>JO 08.05.27</i>
	Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986	
	Dwg. Rev. <u>A</u> Folio Rev. <u>A</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>JO 08.05.27</i>
	Visually inspect for proper formation of each part	<i>PTC</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3656-1 PAR #: N/A Fault Category: Prod / Thermoforming NCR: Yes No DQA: D Date: 08/05/27  
 QA: N/C Closed: D Date: 08/05/27

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.27	4	Did not form properly. too much sag.	<u>D</u> <u>asura</u>	Scrap & Replaces at 1 m <u>105494</u>	<u>PL.</u> <u>08.05.27</u>	<u>D</u> <u>08.05.27</u>	<u>D</u> <u>08.05.27</u>	<u>D</u> <u>08.05.27</u>

NOTE: Date & initial all entries

Date: Monday, 5/26/2008 1:09:47 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 39494

Part Number: D36561

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

PP

08/05/27

(X)

6.0 HAND FINISH TH HAND FINISHING THERMOFORMING



(X)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

DL. 08.05.27.

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(X)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL. 08.05.27

Check dimensions to ensure conformity to drawing tolerances.

8.0 QC5 INSPECT WORK TO CURRENT STEP



08/05/27 (X)

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: P.PP. 38502

08/05/27

(X)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/05/28 (X)

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-05-27

Job Completion

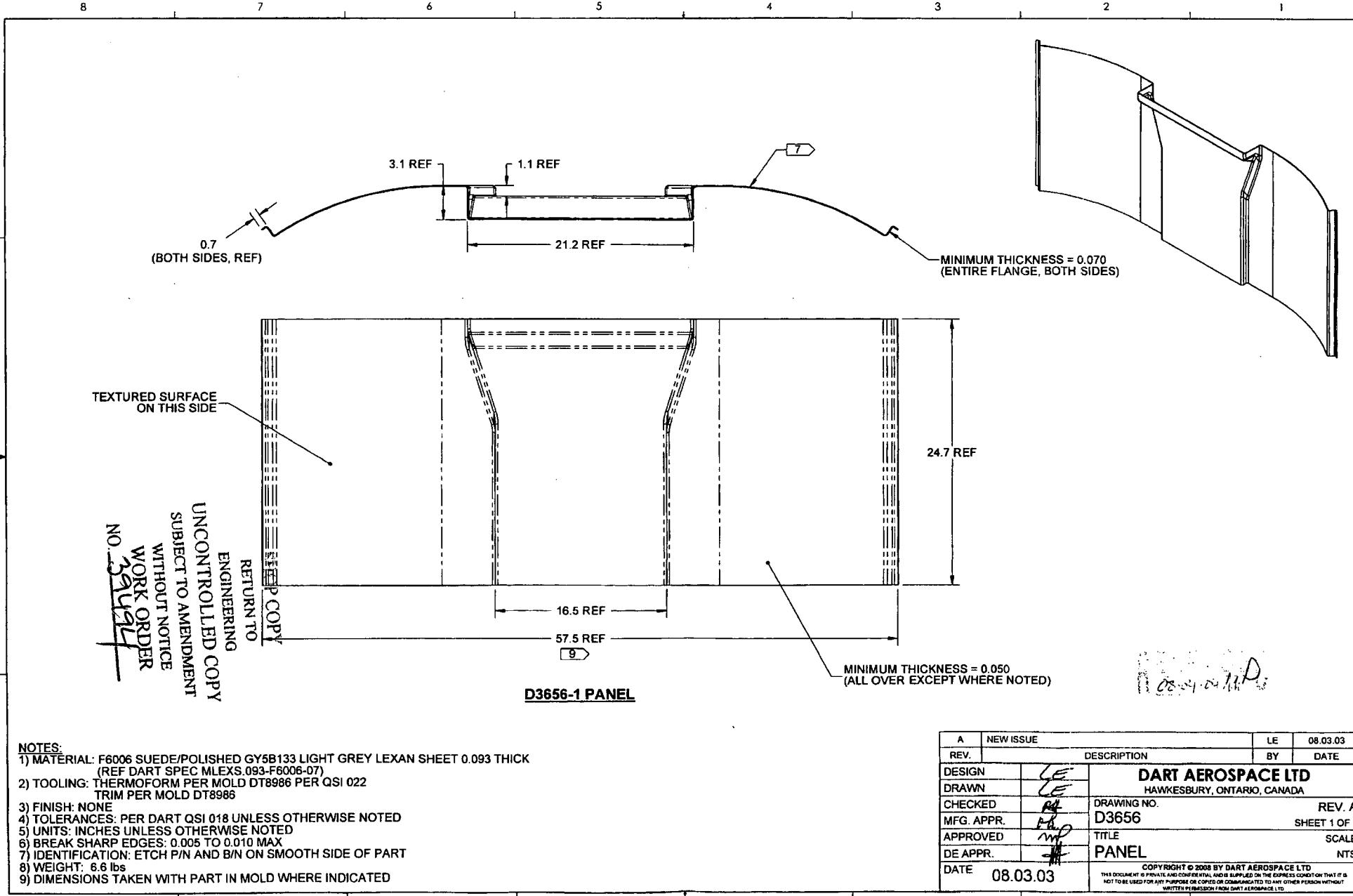


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

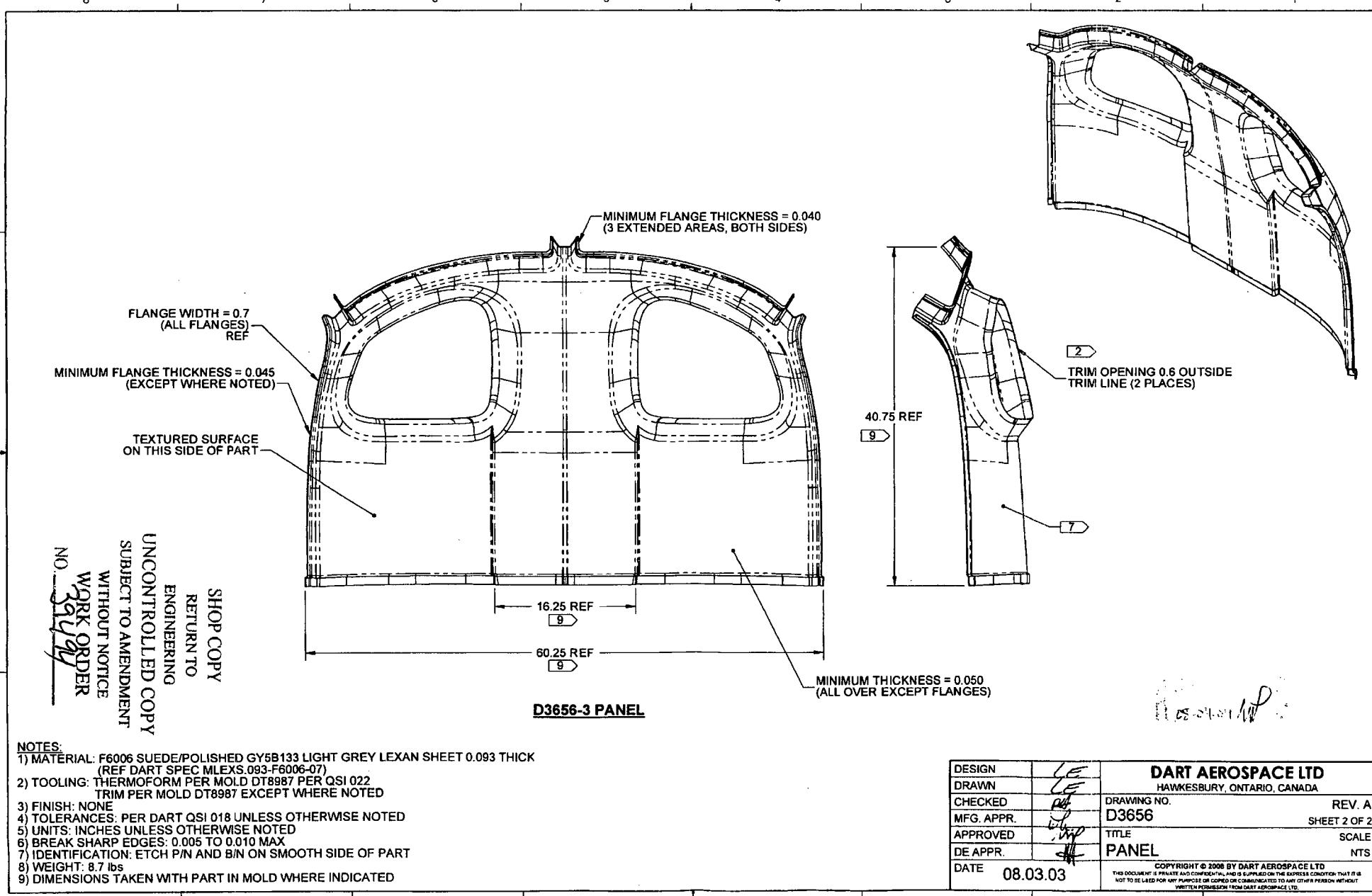


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	37494
Description:Aft Canoy	Part Number:	D3656-1
Inspection Dwg: D3656 Rev: A		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

First Article  Prototype

## (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	PL
Free of visual flaws (bumps, cracks, voids, etc.)	PL

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3-5c Rev. A and record below

Measured by: DT  
Date: 03-05-27

Audited by:	DB
Date:	05/27

Prototype Approval: NA / 1  
Date: 1/1/2010

Rev	Date	Change	Revised by	Approved
		New Issue		

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